



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10307-041-PO
Job Sheet 185621



Part No: RB 92700-10307-041-PO

Job Qty: 1 ea ^{DAG} 21 ₉₋₈₉

Part Name: TR Nut Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10307-041 Rev.A IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs	12/14/18	12/14/18	0.00	0.00	Purchasing		
110	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC6		DEC 21 2018 68
130	Small Fab	3 pcs	12/14/18	12/14/18	0.00	0.30	Small Fab-2		9-89
140	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC5		
150	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3		
160	QC21-FG	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DEC 21 2018

Part Op 100 - Issue P/O: 041341 MANUFACTURE RB 92700-10307-041 AS PER DWG Supplier: ARROW TECH MACHINE
Descriptions: WORKS -Certificate of conformity is required

130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10307-041P	TR Nut Wrench	3 Ea (1 ea)	100-Purchasing	5139661

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10307-041P	3	0	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 8:40 AM dart.Lussier.Patrick



Container No: S139662



Part: RB 92700-10307-041

Job No: 185621

Serial No/Batch: S139662

Revision: A

Inspector:

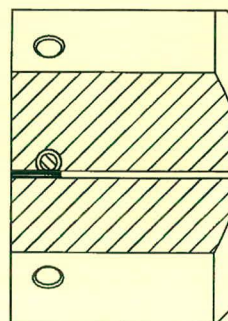
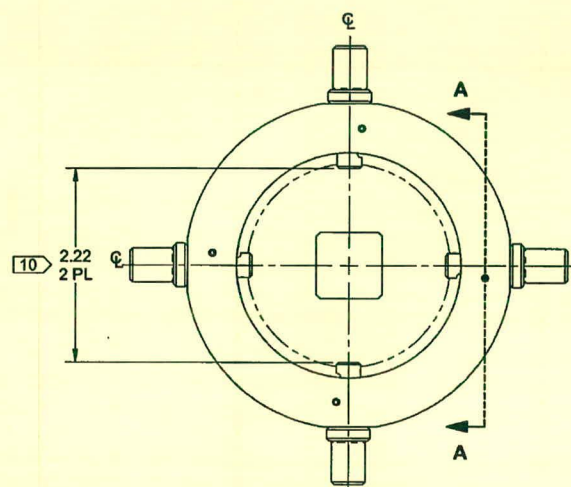
Exp Date:

Instructions:

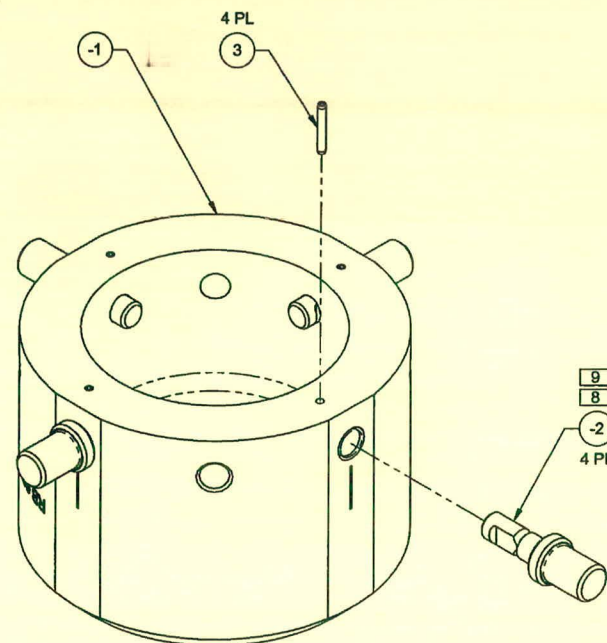
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/20/18

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10307-041-1	HOUSING
-2	4	RB 92700-10307-041-2	PIN
3	4	McMaster#90692A906 OR EQUIV.	STEEL SPRING PIN 5/64" DIA. X 9/16" LG.



SECTION A-A



RB 92700-10307-041 TR NUT WRENCH

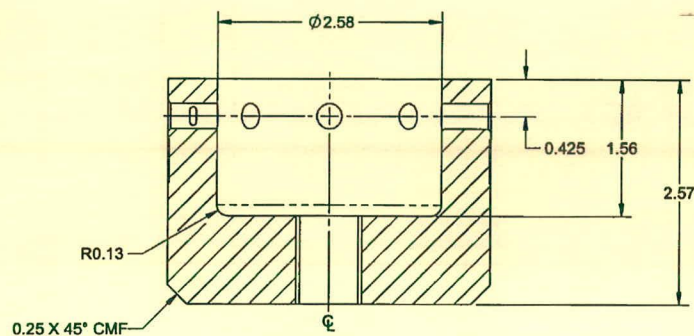
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$

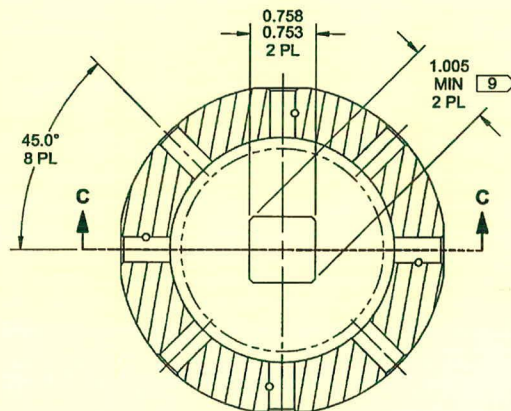
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) INSERT ITEM -2 INTO ITEM -1. THEN ALIGN ENGRAVED LINE ON ITEM -1 WITH SLOT ON ITEM -2. THEN INSTALL ITEM 3 FLUSH WITH SURFACE OF ITEM -1.
- 9) PINS ROTATE FREELY WHEN ENGAGED. CAN NOT BE PULLED OUT UNTIL ALIGNED. PINS CAN MOVE FREELY IN AND OUT ONCE ALIGNED.
- 10) DISTANCE BETWEEN FLATS OF ITEM -2 MEASURED WITH PINS ENGAGED
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

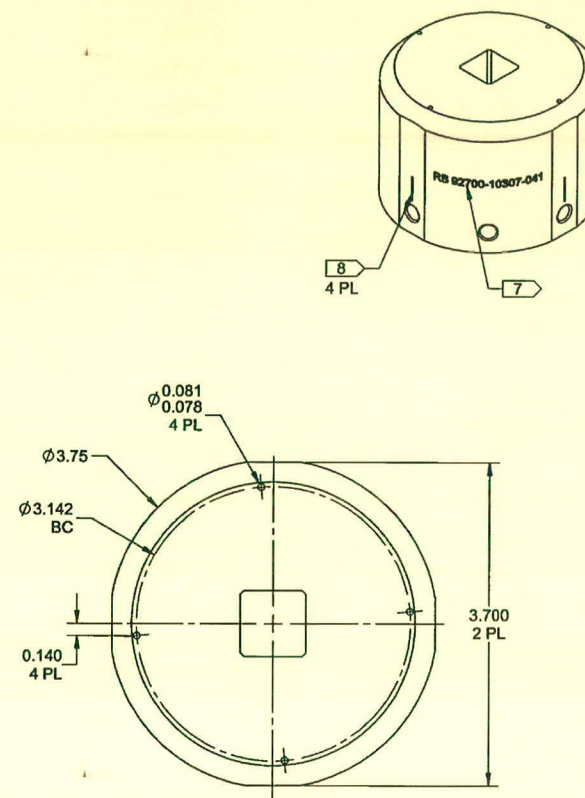
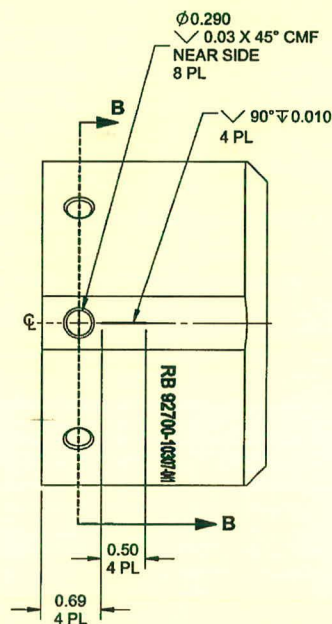
A	NEW ISSUE	18-626	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	JFS	RB 92700-10307-041	SHEET 1 OF 3
APPROVED	VH	TITLE	SCALE
DATE 9/4/2018		TR NUT WRENCH	NTS
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SECTION C-C



SECTION B-B

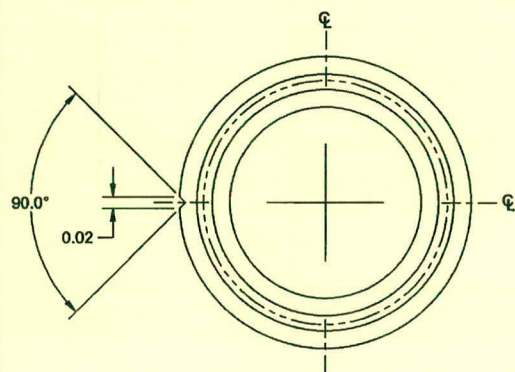


RB 92700-10307-041-1 HOUSING

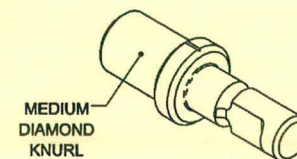
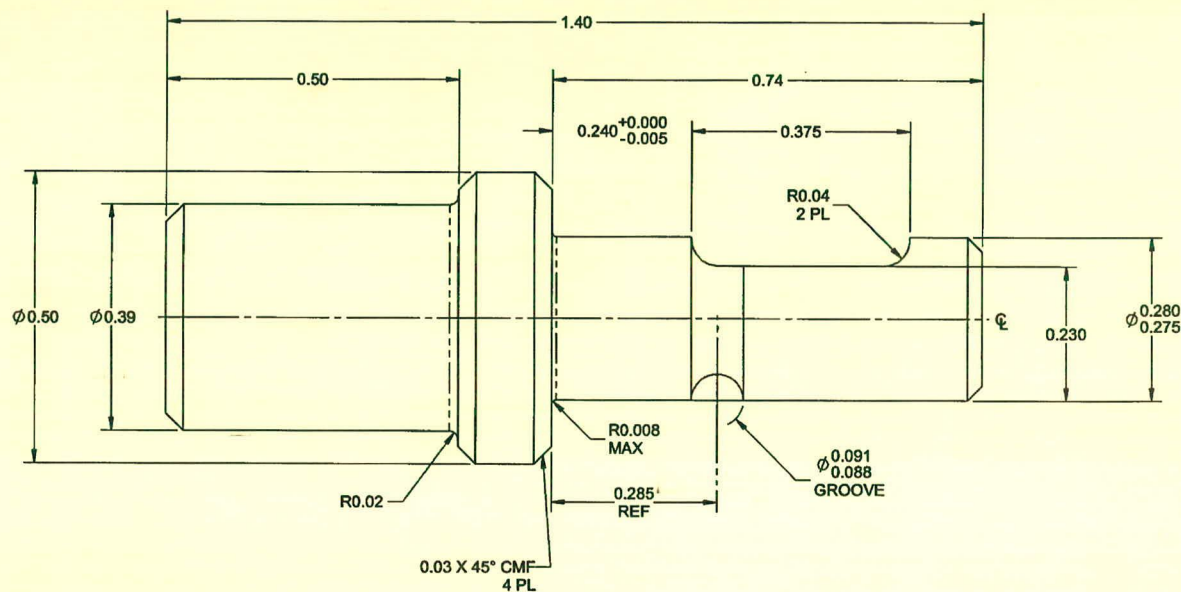
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN
- 8) FILL LINES WITH WHITE PAINT
- 9) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	JFS	RB 92700-10307-041	SHEET 2 OF 3
APPROVED	✓	TITLE	SCALE
DATE	9/4/2018	TR NUT WRENCH	NTS
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RB 92700-10307-041-2 PIN



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
 X.XX = $\pm 0.01"$ / $\pm 0.5"$
 X.XXX = $\pm 0.005"$ / $\pm 0.1"$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	JFS	RB 92700-10307-041	SHEET 3 OF 3
APPROVED	VH	TITLE	SCALE
DATE 9/4/2018		TR NUT WRENCH	NTS
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ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 ✓

Dated: 12/14/2018

Our Order / Job No: 041341-10AWT

Order Qty: 2 ✓

Part Name: TR NUT WRENCH

Part Number: RB 92700-10307-041 ✓

Lot Size: N/A

Ship Date: 12/14/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10307-041

Rev: A

Material Size and Type: -1,-2/ 4140 Q & T STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV D; ZINC PLATE YELLOW: ASTM B633
TYPE 2 CLASS 1

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: _____

12/17/18

Signed: _____

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

DAS
68
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041341

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
41	185652	RB 92700-10400-041-41P			16" Pin Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
42	185654	RB 92700-10400-041-43P			Cockpit - Rig Pins REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
43	185655	RB 92700-10400-041-45P			5" Pin Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
44	185656	RB 92700-10400-041-49P			Boost Mid Pin REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
45	185657	RB 92700-10400-041-52P			Rotor Head - Cross Bar REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
46	185658	RB 92700-10400-041-63P			Cyclic - Rig Block Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
47	185659	RB 92700-10400-041-64P			Rotor Head - Rig Plate REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
48	187839	RB 92700-10307-041P			TR Nut Wrench REV A	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$1,694.00/Ea	\$1,694.00
Grand Total: \$79,094.31													



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 1 OF 2

Date: 12/14/2018 ✓
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	SEAL INSTALLATION TOOL	RB 92700-10300-041 - 1
3 ✓	PLATE ASSEMBLY	RB 92700-10303-041 - 4
3 ✓	WRENCH ASSEMBLY	RB 92700-10303-041 - 6
3 ✓	TGB & IGB SEAL INSTALLER ASSEMBLY	RB 92700-10305-041 - 4
2 ✓	TR NUT WRENCH	RB 92700-10307-041 ✓
3 ✓	TAIL BLADE WRENCH (DE-ICE) WELDMENT	RB 92700-10309-042 ✓
3 ✓	TORQUE REACTOR	RB 92700-10314-101 ✓
3 ✓	SIGHT GUAGE REMOVAL TOOL	RB 92700-10328-041 ✓
3 ✓	ENGINE DRIVE SHAFT REMOVAL TOOL ASS	RB 92700-10333-041 ✓
3 ✓	BEARING SPANNER WRENCH	RB 92700-10340-101 ✓
3 ✓	SEAL REMOVAL ASSEMBLY	RB 92700-10350-041 - 5
3 ✓	BEARING ALIGNMENT TOOL	RB 92700-10356-041 ✓
3 ✓	TORQUE ADAPTER	RB 92700-10750-101 ✓
3 ✓	INPUT MODULE WRENCH	RB 92700-10750-102 ✓
3 ✓	RIG PLATE SCREW	RB 92700-10400-041-6 ✓
3 ✓	PIT STOP GUAGE	RB 92700-10400-041-7 ✓
3 ✓	RIG GUAGE PLATE (SPARES)	RB 92700-10400-041-9 ✓

Received by: _____
Packaged by: _____
Checked by: _____

Thank You



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 2 OF 3

Date: 12/14/2018
PO Ref: 041341
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

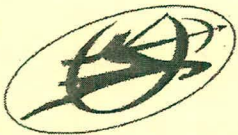
Qty	Item	Part No.
3	TRS LEFT STOP GUAGE	RB 92700-10400-041-11
3	RH MID GUAGE	RB 92700-10400-041-12
3	TR MID BLOCK	RB 92700-10400-041-13
3	ROLL STOP GUAGE	RB 92700-10400-041-14
3	COLL STOP GUAGE	RB 92700-10400-041-16
3	LIMITER GUAGE	RB 92700-10400-041-18
3	LH MID GUAGE	RB 92700-10400-041-20
3	FWD MID GUAGE	RB 92700-10400-041-22
3	RH MID GUAGE	RB 92700-10400-041-24
3	MIX PIN P / C / R	RB 92700-10400-041-26
3	MIX PIN YAW	RB 92700-10400-041-28
153	RIG PIN ASSEMBLY	RB 92700-10400-041-30
3	BOOST COL LOW	RB 92700-10400-041-33
3	3.5" PIN ASSEMBLY	RB 92700-10400-041-36
3	9" PIN ASSEMBLY	RB 92700-10400-041-39
3	16" PIN ASSEMBLY	RB 92700-10400-041-41
3	COCKPIT - RIG PINS <i>Missing CFC</i>	RB 92700-10400-041-43

Received by: _____

Packaged by: *ADD*

Checked by: *CF*

Thank You



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 3 OF 3

Date: 12/14/2018 ✓
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	5" PIN ASSEMBLY	RB 92700-10400-041-45 ✓
3 12	BOOST MID PIN	RB 92700-10400-041-49 ✓
3 ✓	ROTOR HEAD - CROSS BAR	RB 92700-10400-041-52 ✓
3 ✓	CYCLIC - RIG BLOCK ASSEMBLY	RB 92700-10400-041-63 ✓
3 ✓	ROTOR HEAD - RIG PLATE	RB 92700-10400-041-64 ✓

Received by: _____

Packaged by: HAIR

Checked by: CP

Thank You

